

BLUE WHITE

Dart Aerospace Ltd.


Date: Friday, 13/06/2008 1:57:07 PM  
User: Linda Lacelle

Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L/L3/L4 HIGH GEAR SKID
Job Number	: 39840		
Estimate Number	: 10525		
P.O. Number	:	Part Number	: D206642411
This Issue	: 13/06/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: BLUE
First Issue	: / /	Project Number	: N/A
Previous Run	: 39839	Drawing Revision	: L
		Type	: SKIDTUBES
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 30/06/2008
Comment	: Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM Est Rev:L 07-12-04 ECN 1080p DD verified by:		

Qty: 1 Um: Each



Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
		



Comment: DOCUMENT CONTROL  
Photocopy bluefile and create labels per PPP D206-642-411 CHG004 *S 08/07/02*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
		



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

3.0	39840A	206 L HIGH GEAR SKIDTUBE
		

Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE  
1 x D206-642-441 Batch *39840A* *SEP 2/7/2*

4.0	D206648011	GHW Modification
		

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
GHW Modification Kit  
Batch: *B 39840*  
ATTN: BLUE D2659 *B 39126*

5.0	D2652	Bushing
		

Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
16 D2652 Bushing *B 38815* *5X B 10930* *11X*  
1 D206-642-441(REF) *SEP 8/7/2* *1/16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39840

Part Number: D206642411BL

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D2655 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2655 ~~BLUE~~

Tow Ring

~~3512~~

34613

sq

7.0 D2712 Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

10 D2712

Set Screw

B37765

sq

8.0 D29321 Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2932-1 ~~BLUE~~

Saddle

B34832

sq

9.0 D29331 Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2933-1 ~~BLUE~~

Saddle

B34663

39773

sq

10.0 D2934 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2934

Saddle Spacer

39688

sq

11.0 D2935 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2935

Saddle Spacer

B37867

8/12

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 39840

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2938-1 BLUE Saddle

39821 551  
34603

54

13.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2939-1 BLUE Saddle

36143 54

8/12/26

54

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2968-043 BLUE Tow Ring

39945  
B35009

8/16/26

37380 8/12/26 54

8/12/26

54

15.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN3-41A

Bolt

M107242

8/12/26

54

16.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt

M100857

8/12/26

8/12/26 (1)

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 39840

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN46A

Bolt



sq

Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt M106662

*[Handwritten signature]*

18.0

AN511A

Bolt



sq

Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt M105810

*[Handwritten signature]*

19.0

AN512A

Bolt



sq

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

AN5-12A

Batch: M104885

*[Handwritten signature]*

20.0

AN513A

Bolt



sq

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch

M107321

*[Handwritten signature]*

21.0

AN960JD10

Washer



sq

Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer M108077

*[Handwritten signature]*

22.0

AN960JD1016

Washer



sq (14)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN960JD1016

Washer M5519

8/12

*[Handwritten signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Friday, 13/06/2008 1:57:07 PM  
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## Process Sheet

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Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 39840

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD416

Washer



scf

Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Qty Part Number

Description Batch

25 AN960JD416

Washer

M107939

*[Handwritten signature]*

24.0

AN960JD516

Washer



scf

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 AN960JD516

Washer

M107959

*[Handwritten signature]*

25.0

AN9704

Washer



scf

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN970-4

Washer

M107715

*[Handwritten signature]*

26.0

MS21042L3

Nut



scf

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 MS21042L3

Nut (or -3)

167665  
M107644

*[Handwritten signature]*

27.0

MS21042L4

Nut



scf

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M107478

8/7/2

*[Handwritten signature]*

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

28/7/2

*[Handwritten signature]*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/06/2008 1:57:07 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 39840

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location: \_\_\_\_\_

PPP Rev: D

*Pc 8/7/2* ①

30.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/07/03* *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 08-07-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

27

Date: Thursday, 12/06/2008 3:42:16 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4 HIGH GEAR SKID  
 Job Number : 39840  
 Estimate Number : 10525  
 P.O. Number :  
 This Issue : 12/06/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D206642411  
 First Issue : / / Type : LANDING GEAR Drawing Number : N/A  
 Previous Run : 34568 Drawing Revision :  
 Written By : Due Date : 30/06/2008 Qty: 1 Um: Each  
 Checked & Approved By : JUD 08.6.12  
 Comment : Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM

## Additional Product

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



*make new label*  
*02/08/07/02 red + white*  
 JUD 08.6.16



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

2.0

39840A

206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE  
 D206-642-441 B

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

4.0

D2652

Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)  
 Pick: Packing Kit  
 Qty Part Number Description Batch  
 24 D2652 Bushing  
 1 D206-642-441(REF)

5.0

D2655

Ring

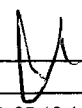



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick: Packing Kit  
 Qty Part Number Description Batch  
 1 D2655 Tow Ring

Date: Friday, 13/06/2008 1:57:31 PM  
User: Linda L. Mcelle

**Process Sheet**

~~10/07~~ white 28/06/25

**Customer** : CU-DAR001 Dart Helicopters Services **Drawing Name** : 206 L HIGH GEAR SKIDTUBE  
**Job Number** : 39840A  
**Estimate Number** : 10522  
**P.O. Number** : **Part Number** : D206642441  
**This Issue** : 13/06/2008 **S.O. No.** : **Drawing Number** : D2650 REV E  
**Prsht Rev.** : NC **Project Number** : N/A  
**First Issue** : / / **Type** : SKIDTUBES **Drawing Revision** : E  
**Previous Run** : 39839A **Material** :  
**Written By** :  **Due Date** : 30/06/2008 **Qty:** 1 **Um:** Each  
**Checked & Approved By** :   
**Comment** : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM  
Est Rev: I 08-05-01 add QC3 DD verified by: EC

**Additional Product**

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 DC DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

2.0 D2620 Skidtube, 206 Skidtube



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

B39178

D H 8-6-16

3.0 D2647 Cap



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2647

Fwd Cap

35475

BE 8-6-16

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



**Comment:** LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod

M108096/M107877

BE 8-6-16

4-Grind weld flush to cap on top surface only.

H 8-6-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/06/2008 1:57:31 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39840A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

H  
8-6-17

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

D H 8-6-17

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 8-06-17

7.0

D26547

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B35994

D H 8-6-17

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 8-06-17

Time: 3:45

Finish Date: 8/6/18

Time: 7:15 AM

BE  
8-6-17



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39840A

Part Number: D206642441

Job Number:



Seq. #: Machine Or Operation: Description :

A/R Sikaflex-291

Sikaflex expiry date:

*M107893*  
*10/2008*

*BE 8-06-17*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8* *S* *08/06/18* *80*

10.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

*237859*

*BE 08/06/18*

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R

Aluminum Rod

*M107877*

*BE 08/06/18*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

*7* *8-6-18*

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

12.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

*34599*

*SL 8-6-18*

13.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

*107707*

*SL 8-6-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39840A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets 102515

SL 8-6-18

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

SL 8-6-18

16.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/06/18

(X)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/18

(X)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

(IX)

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: -PRIME

-SPRAY PAINT BLUE DEFLEET

-CLEAR DEFLEET

M107925

see attachment

S.031

01/07/2008

07.34

319.4

F

#1

#2

#3 D206642441

#4

20.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

BL

08-07-01

(X)

21.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B34591

M/L 08/07/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/06/2008 1:57:32 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39840A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265615

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B 34596

m-l

23.0

D265623

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B 34597

m-l

24.0

D265637

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B 34510

m-l

25.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B 39789

m-l

26.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

or (see QSI 017)

M 105814

m-l 08/07/01

(IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/06/2008 1:57:32 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39840A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD10L

Washer



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M104885

m-l

28.0

MS27039108

Screw



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

62 MS27039-1-08

Screw

M108077

m-l

29.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

BLUE Plugs

white

B38273

m-l

30.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

B39784

m-l

31.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M105426

m-l 08/07/01

(1X)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/06/2008 1:57:32 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39840A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

M106541

m-l

33.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2646

Aft Cap

B37755

m-l

34.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date:

M107888

08/11

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

M107888

08/11

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

M107892

m-l 08/07/01

BR 08-07-02

35.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/06/2008 1:57:32 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39840A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP 39840 Pe 8/7/2 (L)

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/03 [Signature]

Job Completion



mf 08-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED

16 04 17

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

**NOTES**

- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- DRILL  $\varnothing$ 0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT


WITHOUT NOTICE

WORK ORDER

NO. 39890A

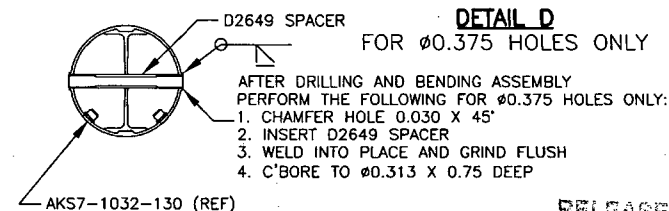
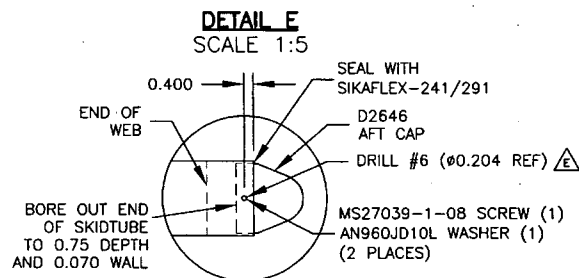
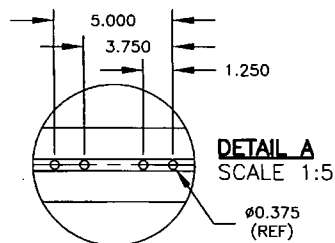
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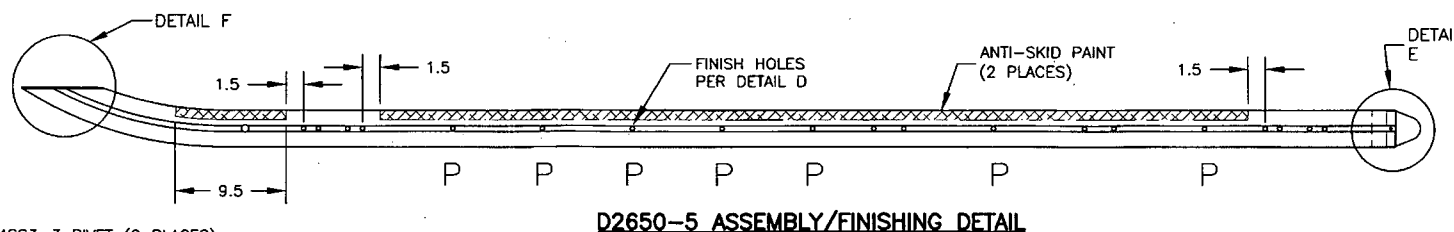
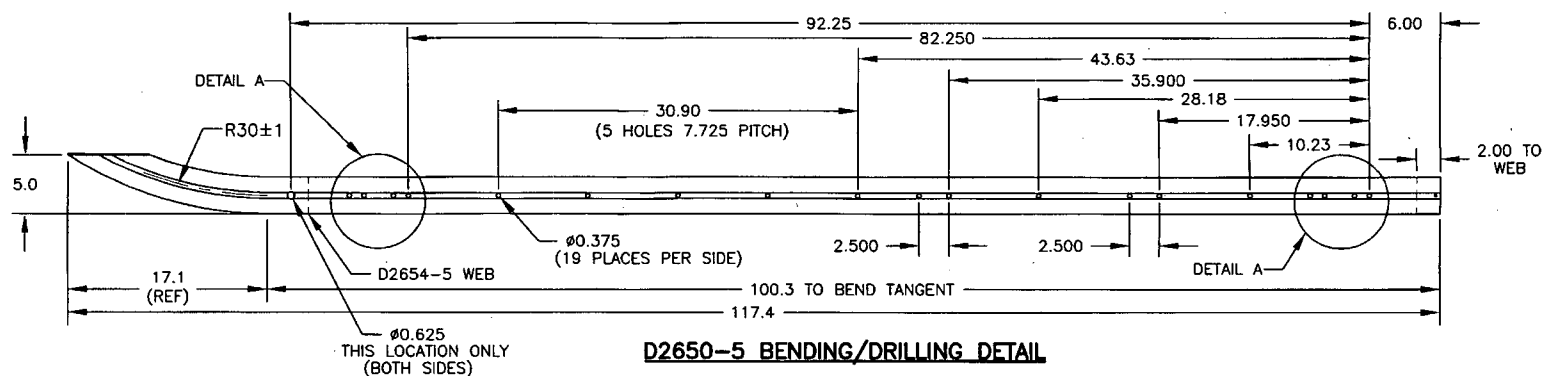
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	CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. <b>D2650</b>	REV.  SHEET 2 OF
	DATE <b>06.03.30</b>	TITLE <b>SKIDTUBE</b>		SCALE <b>1:1</b>







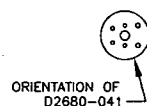
RELEASED



**DETAIL F (NOT TO SCALE)**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 370204

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DATE 06.03.30		DRAWING NO. D2650			
TITLE SKIDTUBE					



NO. 155

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 319629  
Part number: D206 642 641  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[☒] fail[ ]

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier Pet Duval Date of Test Coupon 08-05-09  
Welder Barclay Elliot Date of Test Coupon 08-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date: Wednesday, 25/06/2008 10:04:19 AM  
User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L HIGH GEAR SKIDTUBE
Job Number	: 39840A		
Estimate Number	: 10522		
P.O. Number	:	Part Number	: D206642441
This Issue	: 25/06/2008 S.O. No. :	Drawing Number	: D2650 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 13/06/2008 Type : SKIDTUBES	Drawing Revision	: E
Previous Run	: 39839A	Material	:
Written By	:	Due Date	: 30/06/2008 Qty: 1 Um: Each
Checked & Approved By	: <i>MF 08-06-25</i>		
Comment	: Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM Est Rev: I 08-05-01 add QC3 DD verified by: EC		

**REFERENCE ONLY**

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Job Completion

